

DAS
6
9-88

MAY 13 2015

Work Order ID 117759

Thursday, May 01, 2014 10:44:22 AM

117759

Page 2

Item ID: D412-694-011 Accept ***N9000040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Spacedoor™ Installation Clear Windows
Start Date: 5/1/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 12/31/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
160	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-694-011								
	Location: <u>FG018</u>								
	PPP Rev: _____								
170									
170	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

MAY 13 2015

MAY 12 2015

Picklist Print

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Page 1

Work Order ID: 117759

117759

Parent Item: D412-694-011

D412-694-011

Parent Item Name: Spacedoor™ Installation Clear Windows

Start Date: 5/1/2014

Required Date: 12/31/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A05.04.27New IssueKJ/RF
IPP Rev:B 07-01-26 Added DSI 9363-011 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
BSP45 *RSP45* Commercial Rivet		Purchased	No			140	Each	477.0000	48	48			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST282	120417		477	MB/26		48		MAR 03 2015	
							477						
D2126 *D2126* Seal		Manufactured	No			140	f	404.6800	12.1666	13			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST405			0.68						
					102729		0.68						
				ST406			404						
					110653		404						
(D2126-0730) cut qty (2) at 73.00" as per dwg ***per kit***													
D3090-1 *D3090-1* Shim 0.250		Manufactured	No			140	Each	23.0000	4	4			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST025			23						
					18037		23						

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Work Order ID: 117759

117759

Parent Item: D412-694-011

D412-694-011

Parent Item Name: Spacedoor™ Installation Clear Windows

Start Date: 5/1/2014

Required Date: 12/31/2014

Start Qty: 1.00

Required Qty: 1.00

D3090-3

Manufactured No

140 Each

24.0000

4 4

D3090-3

Shim 0.125

DAS
26
9-89

Location

ST025

Loc Qty

24

Loc Code

**

DAS 27
MAR 03 2015
DAS 26
9-89

D3108-1

Manufactured No

140 Each

5.0000

D3108-1

Decal

DAS
26
9-89

Location

ST025

Loc Qty

5

Loc Code

**

DAS 27
MAR 03 2015
DAS 26
9-89

D3108-2

Manufactured No

140 Each

5.0000

D3108-2

Decal

DAS
26
9-89

Location

ST025

Loc Qty

5

Loc Code

**

DAS 27
MAR 03 2015
DAS 26
9-89

D3108-3

Manufactured No

140 Each

11.0000

D3108-3

Decal

DAS
26
9-89

Location

ST025

Loc Qty

11

Loc Code

**

DAS 27
MAR 03 2015
DAS 26
9-89

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Page 3

Work Order ID: 117759

117759

Parent Item: D412-694-011

D412-694-011

Parent Item Name: Spacedoor™ Installation Clear Windows

Start Date: 5/1/2014

Required Date: 12/31/2014

Start Qty: 1.00

Required Qty: 1.00

D3108-5

Manufactured No

140

Each

14.0000

4 4

D3108-5

Decal

DAS
06
9-89

Location

Loc Qty

Loc Code

ST025

14

B9(631)

110719

12

83569

2

**

DAS
27
9-89

DAS
26
9-89

DAS
26
9-89

MAR 03 2015

D3108-7

Manufactured No

140

Each

14.0000

2 2

D3108-7

Decal

DAS
06
9-89

Location

Loc Qty

Loc Code

ST025

14

36723

14

**

DAS
27
9-89

DAS
26
9-89

DAS
26
9-89

MAR 03 2015

D3116-1

Manufactured No

140

f

70.0000

8.3333 9

D3116-1

Seal(SPer Foot)

DAS
06
9-89

Location

Loc Qty

Loc Code

ST414A

70

2489

70

**

DAS
27
9-89

DAS
26
9-89

DAS
26
9-89

MAR 03 2015

(D3116-3-0500) cut qty (2) at 50.00" as per dwg

per kit

D3116-3

Manufactured No

140

f

100.0000

8.3333 9

D3116-3

Seal(SPer Foot)

DAS
06
9-89

Location

Loc Qty

Loc Code

ST414A

100

106992

100

**

DAS
27
9-89

DAS
26
9-89

DAS
26
9-89

MAR 03 2015

(D3116-3-0500) cut qty (2) at 50.00" as per dwg

per kit

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Thursday, May 01, 2014 10:44:21 AM

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Work Order ID: 117759

117759

Parent Item: D412-694-011

D412-694-011

Parent Item Name: Spacedoor™ Installation Clear Windows

Start Date: 5/1/2014

Required Date: 12/31/2014

Start Qty: 1.00

Required Qty: 1.00

D3118-3

Manufactured No

140 Each

12.0000

(4) 4

D3118-3

Sign Assembly

DAS
86
9-89

Location

ST026

100588

Loc Qty

12

12

Loc Code

B125312

(4) 4

DAS
27
9-89

MAR 03 2015

DAS
26
9-89

D3118-5

Manufactured No

140 Each

5.0000

(4) 4

D3118-5

Decal

DAS
86
9-89

Location

ST026

64831

78760

Loc Qty

5

1

4

Loc Code

B123038

(4) 4

DAS
27
9-89

MAR 03 2015

DAS
26
9-89

D3128-1

Manufactured No

140 Each

4.0000

(4) 4

D3128-1

Shim

DAS
86
9-89

Location

ST027

18643

79008

Loc Qty

4

1

3

Loc Code

B122946

(4) 4

DAS
27
9-89

MAR 03 2015

DAS
26
9-89

D3144-15

Manufactured No

140 Each

4.0000

(2) 2

D3144-15

Doubler

DAS
86
9-89

Location

CA

67696

Loc Qty

4

4

Loc Code

B125069

(2) 2

DAS
27
9-89

MAR 03 2015

DAS
26
9-89

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Work Order ID: 117759

117759

Parent Item: D412-694-011

D412-694-011

Parent Item Name: Spacedoor™ Installation Clear Windows

Start Date: 5/1/2014

Required Date: 12/31/2014

Start Qty: 1.00

Required Qty: 1.00

D3300-1

Manufactured No

140

Each

6.0000

2

2

D3300-1

Window

DAS
06
9-89

Location

ST209

Loc Qty

6

Loc Code

56108

6

D412-694-01

Manufactured No

140

Each

0.0000

1

1

D412-694-01

Door Assembly, LH

D412-694-015

Manufactured No

140

Each

0.0000

4

4

D412-694-015

Replacement Clear Window

D412-694-02

Manufactured No

140

Each

0.0000

1

1

D412-694-02

Door Assembly, RH

D412-694-03

Manufactured No

Each

0.0000

1

D412-694-03

Hinge Door Assembly, LH

D412-694-04

Manufactured No

140

Each

0.0000

1

1

D412-694-04

Hinge Door Assembly, RH

DSI 9363-011

Manufactured No

140

Each

1.0000

1

1

DSI 9363-011

Shim

Location

FG123

Loc Qty

1

Loc Code

87462

1

DAS
06
9-89

3116-1-0520

Seal

68-6

86

9-89

Batch: B3916

DAS
27
9-89

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REF

SP 15-04-27

6. PARTS LIST

Qty -011-	Qty -013	Qty -015	Qty -017	Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
X								D412-694-011	SPACEDOOR™ INSTALLATION
	X							D412-694-013	PANEL INSTALLATION (OPTIONAL)
4		X						D412-694-015	REPLACEMENT WINDOW KIT
			X					D412-694-017	BEARING OVERHAUL KIT
				X				D412-694-01	DOOR ASSEMBLY
1					X			D412-694-02	DOOR ASSEMBLY
1						X		D412-694-03	DOOR ASSEMBLY
							X	D412-694-04	DOOR ASSEMBLY
2								D2126-0730	SEAL
4								D3090-1	SHIM
4								D3090-3	SHIM
2								D3108-1	DECAL
2								D3108-2	DECAL
4								D3108-3	DECAL
4								D3108-5	DECAL
2								D3108-7	DECAL
						1	1	D3110-1	ESCUTCHEON
						1	1	D3110-3	HANDLE
				1	1			D3110-5	HANDLE ASSEMBLY
						1	1	D3111-041	PLATE ASSEMBLY
						2	2	D3112-1	GUIDE
						1	1	D3113-1	SPRING
						1	1	D3114-1	PIVOT
				1	1			D3115-1	BRACKET
2								D3116-1-0500	SEAL
						1	1	D3116-11-0180	SEAL
2								D3116-3-0500	SEAL
						1	1	D3116-5-0680	SEAL
				1	1			D3116-7-0680	SEAL
				1	1			D3116-9-0770	SEAL
		1						D3117-1-0980	SEAL RETAINER
		1						D3117-3-0980	SEAL FILLER
4								D3118-3	SIGN ASSEMBLY/
4								D3118-5	SIGN ASSEMBLY/
						1		D3119-041	COVER ASSEMBLY
							1	D3119-042	COVER ASSEMBLY
						1		D3120-1	COVER
							1	D3120-2	COVER
						1		D3120-3	COVER
							1	D3120-4	COVER
				3	3			D3121-041	BRACKET ASSEMBLY ("ROLLER")
				1				D3121-043	BRACKET ASSEMBLY ("ROLLER")
					1			D3121-044	BRACKET ASSEMBLY ("ROLLER")
			7					D3121-21	SCREW

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Revision: B

Date: 04.10.07

Qty -011	Qty -013	Qty -015	Qty -017	Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
			5					D3121-241	BEARING ASSEMBLY
				1	1			D3122-1	LEVER
				2	2			D3123-1	CAM
				1	1			D3124-1	HOOK
				1	1			D3124-2	HOOK
						1	1	D3125-1	LEVER
						1	1	D3125-3	LEVER
						1	1	D3125-5	LEVER
						1	1	D3125-7	LEVER
				1	1			D3126-1	BRACKET ("SLIDER")
				1	1			D3126-3	BRACKET ("SLIDER")
				5	5			D3126-5	BRACKET ("SLIDER")
				1	1			D3127-1	SPACER
						1	1	D3128-1	SHIM
						2	2	D3129-1	LEVER
						2	2	D3130-1	CLEVIS BASE
						1	1	D3131-1	STOP
				1				D3132-041	ROD WELDMENT
					1			D3132-042	ROD WELDMENT
					1			D3133-041	ROD WELDMENT
				1				D3133-042	ROD WELDMENT
						1	1	D3134-1	ROD
						1	1	D3134-3	ROD
				1	1			D3135-041	HANDLE WELDMENT
		1						D3136-041	WINDOW ASSEMBLY
				2				D3137-041	BRACKET ASSEMBLY ("ROLLER")
			1					D3137-3	GUIDE
			1					D3137-5	WASHER
				1				D3138-1	COVER
					1			D3138-2	COVER
				1	1			D3139-1	GUARD
				1				D3139-3	GUARD
					1			D3139-4	GUARD
				1				D3140-05	DOOR
					1			D3140-06	DOOR
						1		D3140-07	DOOR
							1	D3140-08	DOOR
				2	2			D3141-1	SPRING
						1	1	D3143-1	CLEVIS
						3	3	D3143-3	CLEVIS
						1		D3144-1	DOUBLER
						1		D3144-105	DOUBLER
						1		D3144-107	DOUBLER
				1				D3144-109	DOUBLER
				1	1			D3144-111	DOUBLER
					1			D3144-115	DOUBLER
							1	D3144-117	DOUBLER
							1	D3144-119	DOUBLER

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Revision: **B**

Date: 04.10.07

Qty -011	Qty -013	Qty -015	Qty -017	Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
							1	D3144-121	DOUBLER
					1			D3144-123	DOUBLER
				1	1			D3144-13	DOUBLER
				1				D3144-3	DOUBLER
						1		D3145-1	HINGE BRACKET
							1	D3145-2	HINGE BRACKET
						1		D3146-1	HINGE BRACKET
							1	D3146-2	HINGE BRACKET
						2	2	D3147-1	PIN
				2	2			D3148-1	CLEVIS
						2	2	D3149-1	STRIKER PLATE
						2	2	D3150-1	GUIDE
				1	1			D3151-041	DOUBLER ASSEMBLY
				1				D3152-041	BRACKET ASSEMBLY
					1			D3152-042	BRACKET ASSEMBLY
	1							D3153-11	PANEL
	1							D3153-12	PANEL
	1							D3153-13	PANEL
	1							D3153-14	PANEL
	1							D3153-15	PANEL
	1							D3153-16	PANEL
						1	1	D3154-1	KEY
				1	1			D3155-041	BRACKET ASSEMBLY
				1	1			D3155-042	BRACKET ASSEMBLY
				2	2			D3156-1	BRACKET
						2	2	D3157-1	SPACER
						3	3	D3159-041	BRACKET ASSEMBLY
						1		D3159-043	BRACKET ASSEMBLY
							1	D3159-044	BRACKET ASSEMBLY
				12	12			D3162-041	BRACKET ASSEMBLY
				1				D3163-041	COVER ASSEMBLY
					1			D3163-042	COVER ASSEMBLY
				1				D3183-041	BRACKET ASSEMBLY ("ROLLER")
					1			D3183-042	BRACKET ASSEMBLY ("ROLLER")
			2					D3183-045	BEARING ASSEMBLY
				1	1			D3203-1	HANDLE ASSEMBLY
2								D3300-1	WINDOW
				2	2			D3308-1	DOUBLER
				55	55	21	21	80-005-2-8	INSERT (OR SL2052-3-4)
	60							A6K75	RIVNUT
				10	10			AN525-10R6	SCREW
				8	8	4	4	AN525-10R7	SCREW
						8	8	AN960JD10	WASHER
				18	18	4	4	AN960JD10L	WASHER
				13	13	32	32	AN960JD10LL	WASHER
				6	6			AN960JD416L	WASHER
						4	4	AN960JD6L	WASHER
				6	6			AN960JD8	WASHER
						2	2	AN960JD8L	WASHER

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Revision: B

Date: 04.10.07

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. DSI 9309	REV. A SHEET 1 OF 2
DATE 05.09.26		TITLE SEAL KIT	SCALE NTS
A	05.09.26	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND IIN-D412-694 REV. B

REF. CANADIAN STC: SH05-10

REF. FAA STC: SR02086NY

TO CLOSE THE GAP BETWEEN AIRCRAFT AND D412-694-01/-02 DOOR ASSEMBLY IT IS ACCEPTABLE TO INSTALL D3116-9-0520 SEAL AS SHOWN BELOW IN LIEU OF INSTALLING THE D3116-3-0520 SEAL PER IIN-D412-694.

ADD THE FOLLOWING PARTS TO THE LIST OF IIN-D412-694. CUSTOMERS WITH EARLY MODEL D412-694-011 KITS CAN PROCURE THE DSI 9309-011 KIT FROM DART TO DO THIS MODIFICATION.

-011	Part Number	Description
X	D412-694-011	SPACEDOOR MODIFICATION
X	DSI 9309-011	SEAL KIT
2	D3116-9-0520	SEAL
2	D3144-15	DOUBLER
48	BSP45	RIVET

PROCEDURE:

- 1) LOCATE D3116-9-0520 SEAL ON D412-694-01/-02 DOOR ASSEMBLY SO THAT IT WILL REST AGAINST EXISTING AIRCRAFT SEAL WHEN DOOR IS CLOSED. ENSURE PROPER ORIENTATION OF SEAL.
- 2) TRIM D3144-15 DOUBLER AND D3116-9-0520 SEAL AS NECCESARY TO CLEAR BRACKETS ON AFT EDGE OF DOOR. ENSURE MINIMUM EDGE DISTANCE OF 0.40" (10 mm) FROM THE RIVET HOLES.
- 3) TRANSFER DRILL Ø0.129" (#30) FROM DOUBLER, THROUGH SEAL AND INTO THE DOOR. DEBURR AND INSTALL DOUBLER & SEAL USING BSP45 RIVETS. SEAL RIVETS WITH RTV-732 SEALANT.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 05.09.26
CERT. NO.: SH05-10
ISSUE NO.: 1

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Work Order ID 117759

Thursday, May 01, 2014 10:44:22 AM

117759

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Item ID: D412-694-011 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Spacedoor™ Installation Clear Windows
Start Date: 5/1/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 12/31/2014 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan: CL Date: 17/11/21 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A	Rev N/A								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D412-694-011		CHG005						
			007						
140	Pick Kit	0.00							
140									
Packaging	Memo	0.00							
Packaging									
150	QC4- 100% Inspect kits for completeness	0.00							
150									
QC	Memo	0.00							
Quality Control									

MAR 03 2015

Change Record

PAGE 1 OF 1

Part Number: D412-694-011 (& D412-694-01/-02/-03/-04)

Description: SPACEDOOR INSTALLATION

[illegible]

5121794, 5121795, 5121796, 5121797, 5121798, 5121799

Linda Lacelle

From: Caitlin Crooks
Sent: Thursday, October 25, 2018 12:06 PM
To: Linda Lacelle; Jesse White; Jason Leroux; Marie Lajeunesse
Subject: space door

5121800, 5121801, 5121802, 5121803

→ 5121806

Hi Everyone

So RSI is going to take half of the spacedoor kit we have sitting in stock (parts below are what they are going to take.) can you confirm how long physically and how long in plex this is going to take to disassemble.

-011 FF000029

PART NUMBER	DESCRIPTION	QTY
D412-694-04	DOOR ASSY	1 ✓
D412-694-02	DOOR ASSY	1 ✓
D2126-0730	SEAL	1 ✓
D3090-1	SHIM	2 ✓
D3090-3	SHIM	2 ✓
D3108-1	DECAL	1 ✓
D3108-2	DECAL	1 ✓
D3108-3	DECAL	2 ✓
D3108-5	DECAL	2 ✓
D3108-7	DECAL	1 ✓
D3116-1-0500	SEAL	1 ✓
D3116-3-0500	SEAL	1 ✓
D3118-3	SIGN ASSY	2 ✓
D3118-5	SIGN ASSY	2 ✓
D3300-1	WINDON	1 ✓
DS19462-011 ✓	WINDOW SUBSTITUTION KIT	1 ✓

23 items

> 16 items



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

IENT

Send
cont. #s
to ship

CUSTOMER

Customer Code: CROTO01

Sold To: Rotorcraft Support Inc
16425 Hart Street
Van Nuys, CA 91406
USA
Phone: (818) 997-7667
Fax: (818) 997-1513

Ship To: Rotorcraft Support Inc
16425 Hart Street
Van Nuys, CA 91406
USA
Phone: (818) 997-7667
Fax: (818) 997-1513

Order Taker Phone:

Order Taker Email: ccrooks@dartaero.com

Line No	Due Date	Ship Date	Part	Description/Note	Quantity	Unit	Price	Unit	Extended Price
1	10/30/18	10/30/18	D412-694-02	Door Assembly - RH	1	pcs	\$71,065.00USD	pcs	\$71,065.00 USD
				18% Discount AMC Level 2			-18.00		\$-12,791.70
2	10/30/18	10/30/18	D412-694-04	Hinge Door Assembly - RH	1	pcs	\$32,075.00USD	pcs	\$32,075.00 USD
				18% Discount AMC Level 2			-18.00		\$-5,773.50
3	10/30/18	10/30/18	D3090-1	Shim 0.250	2	pcs	\$10.00USD	pcs	\$20.00 USD
				10% Discount AMC Level 2			-18.00		\$-3.60
4	10/30/18	10/30/18	D3090-3	Shim	2	pcs	\$15.00USD	pcs	\$30.00 USD
				10% Discount AMC Level 2			-18.00		\$-5.40
5	10/30/18	10/30/18	D3108-1	Decal	1	pcs	\$142.00USD	pcs	\$142.00 USD
				10% Discount AMC Level 2			-18.00		\$-25.56
6	10/30/18	10/30/18	D3108-2	Decal	1	pcs	\$52.00USD	pcs	\$52.00 USD
				10% Discount AMC Level 2			-18.00		\$-9.36
7	10/30/18	10/30/18	D3108-3	Decal	2	pcs	\$123.00USD	pcs	\$246.00 USD
				10% Discount AMC Level 2			-18.00		\$-44.28
8	10/30/18	10/30/18	D3108-5	Decal	2	pcs	\$123.00USD	pcs	\$246.00 USD
				10% Discount AMC Level 2			-18.00		\$-44.28
9	10/30/18	10/30/18	D3108-7	Decal	1	pcs	\$100.86USD	pcs	\$100.86 USD
10	10/30/18	10/30/18	D3116-1	Seal (\$ Per Foot) S121805	1	pcs	\$142.00USD	pcs	\$142.00 USD
				10% Discount AMC Level 2			-18.00		\$-25.56
11	10/30/18	10/30/18	D3116-3	Seal (\$ Per Foot) S121806	1	pcs	\$142.00USD	pcs	\$142.00 USD
				10% Discount AMC Level 2			-18.00		\$-25.56
12	10/30/18	10/30/18	D3118-3	Sign Assembly	2	pcs	\$1,968.00USD	pcs	\$3,936.00 USD
				10% Discount AMC Level 2			-18.00		\$-708.48
13	10/30/18	10/30/18	D3118-5	Decal	2	pcs	\$750.00USD	pcs	\$1,500.00 USD
				10% Discount AMC Level 2			-18.00		\$-270.00
14	10/30/18	10/30/18	D3300-1	Window	1	pcs	\$101.00USD	pcs	\$101.00 USD
				10% Discount AMC Level 2			-18.00		\$-18.18
15	10/30/18	10/30/18	D2126	Locking Seal (Sold Per Foot) S121797	1	pcs	\$130.00USD	pcs	\$130.00 USD
				10% Discount AMC Level 2			-18.00		\$-23.40
16	10/30/18	10/30/18	DSI 9363-011	Shim	2	pcs	\$656.00USD	pcs	\$1,312.00 USD
				10% Discount AMC Level 2			-18.00		\$-236.16

Sub Total \$91,234.84 USD

Grand Total \$91,234.84 USD

ORDER NOTES